



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6405G02131-3G-PO

Job Sheet 185301



Part No: RBW6405G02131-3G-PO **Job Qty:** 2 ea

Part Name: Tail Rotor Blade Damper Attachment Bushing Removal



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/24/18

Job Tracking No:

Due Date: 12/17/18

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBW6405G02131-3G Rev.D IPP Rev. A 18.10.22 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	2 pcs		12/17/18	0.00	0.00	Purchasing		DEC 18 2018
110	Packaging	2 pcs		12/17/18	0.00	0.00	Packaging2		DEC 18 2018
120	QC	2 pcs		12/17/18	0.00	0.00	QC6		
130	Packaging	2 pcs		12/17/18	0.00	0.00	Packaging3		
140	QC21-FG	2 Ea		12/17/18	0.00	0.00	QC21		DEC 19 2018

Part Op 100 - Issue P/O: 041367 MANUFACTURE RBW6405G02131-3G AS PER DWG Supplier: METEC Certificate of Descriptions: conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW6405G02131-3GP	Tail Rotor Blade Damper Attachment Bushing Removal	2 pcs (1 ea)	100-Purchasing	513629

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBW6405G02131-3GP	2	0	0

Part Specifications

Specifications could not be found.



Container No: S138630



Part: RBW6405G02131-3G

Job No: 185301

Serial No/Batch: S138630

Revision: D

Inspector:

Exp Date:

Instructions:

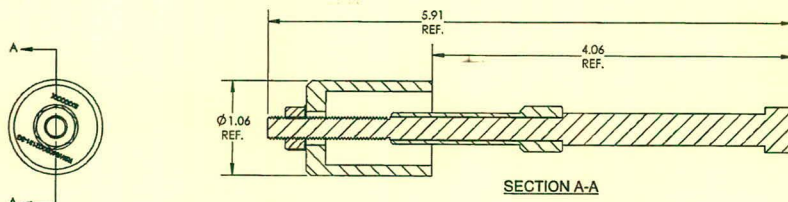
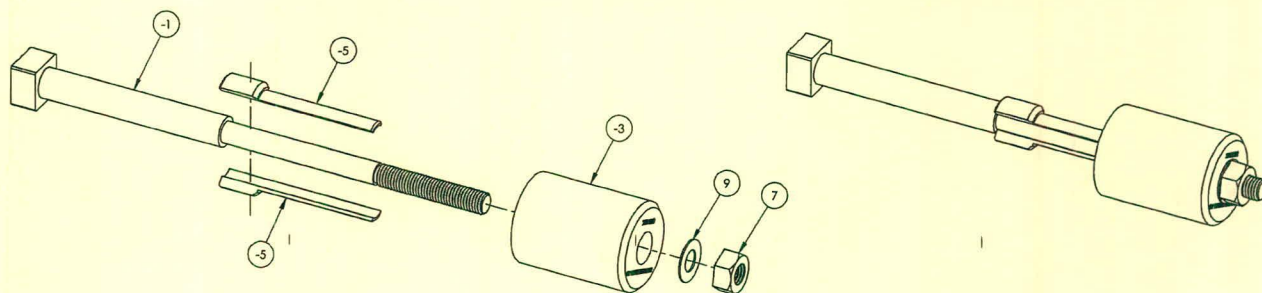
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 12/19/18

Plex 10/24/18 2:38 PM dart.Lussier.Patrick

DEC 18 2008
DEC 18 2008

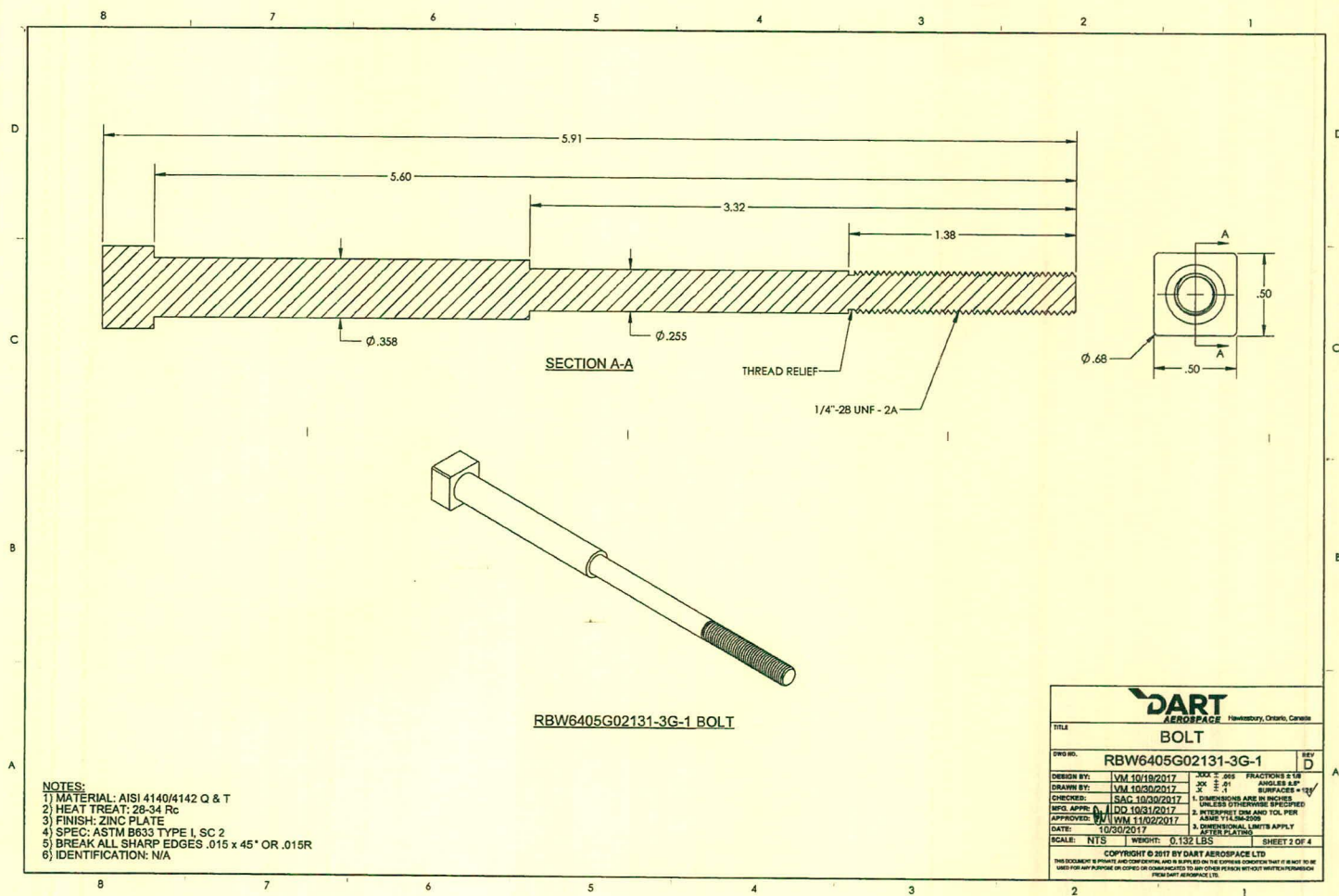
ITEM #	QTY	PART #	TITLE	PG	REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
-1	1	RBW6405G02131-3G-1	BOLT	2	1	CHD TITLEBLOCK WAS RED BARN IS DART. -1 CHD DIM WAS 4X.03 X 45° IS 4X R.34. -5 ADDED DIM (.338), CHD DIM WAS 1.430 IS 1.45.	14-0205	10/31/2014	DJN	JAG
-3	1	RBW6405G02131-3G-3	BELL	3	2	-1 AND -5 CHD MATERIAL CALL OUT WAS 4140 Q&T IS 4140 Q&T / 4142 Q&T. -5 ADDED PART MARK FOR PAIRS NOTE.	15-0284	9/10/2015	RJC	JAG
-5	2	RBW6405G02131-3G-5	QUARTER BELL	4	3	-1 CHD MATL WAS 4140 Q&T/4142 Q&T IS 4140/4142. ADDED HEAT TREAT RC 28-34. CHD FINISH WAS CAD PLATE YELLOW QQ-P-416 TYPE II CLASS II IS ZINC PLATE ASTM B633 TYPE I SC2. -3 DELETED DIMS (.220, (.2X .118). CHD DIM WAS 1.12 IS 1.20. -5 CHD MATL WAS 4140 Q&T/4142 Q&T IS 4140/4142. ADDED HEAT TREAT RC 28-34. CHD FINISH WAS CAD PLATE YELLOW QQ-P-416 TYPE II CLASS II IS ZINC PLATE ASTM B633 TYPE I SC2. DELETED DIM .42.	17-0161	6/23/2017	DPD	JAG
7	1	McMaster94191A150	HEX NUT 1/4"-28 UNF GRADE 8	-	D	-1 & -5 MATERIAL 4140-4142 CHANGED FOR 4140-4142 Q&T Rc ADDED, TEMPLATE UPDATED	17-717	17.10.19	VM	VM
9	1	McMaster95229A420	FLAT WASHER 1/4"	-						

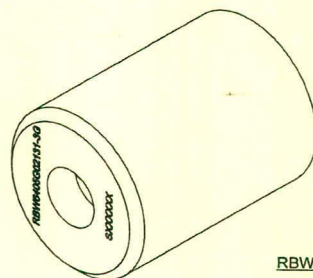
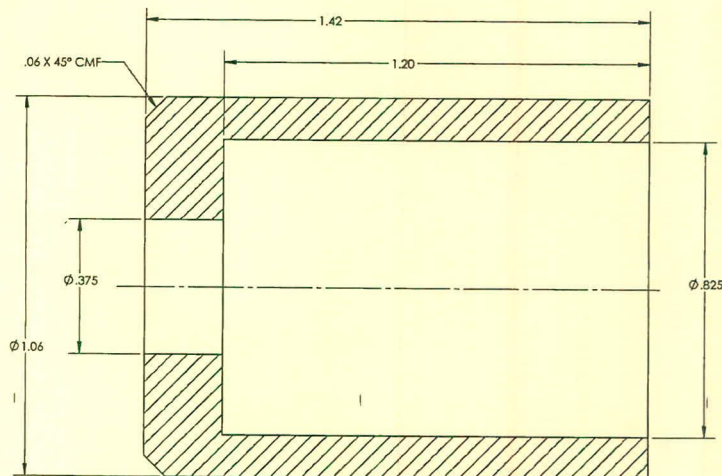
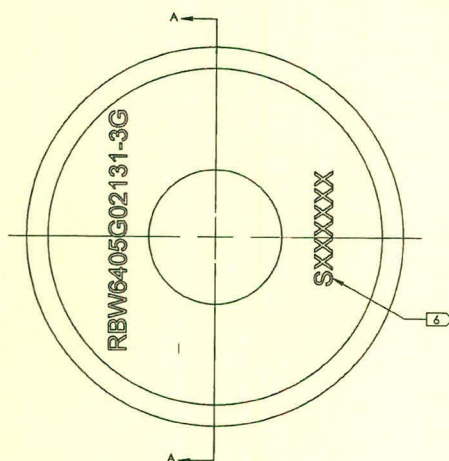


NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) SPEC: N/A
5) BREAK ALL SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) REF AGUSTA T/N: 3G6405G02131

RBW6405G02131-3G TAIL ROTOR BLADE DAMPER ATTACHMENT BUSHING REMOVAL

DART AEROSPACE		Hamilton, Ontario, Canada	
TITLE TAIL ROTOR BLADE DAMPER ATTACHMENT BUSHING REMOVAL			
DWG NO. RBW6405G02131-3G		REV D	
DESIGN BY: VM 10/19/2017	CHKD BY: VM 10/19/2017	FRACTIONS & UNITS 3/16" & 3/8" ANGLES & S.P.	
CHECKED BY: SAC 10/19/2017	DATE: 10/19/2017	DIMENSIONS AND INCHES UNLESS OTHERWISE SPECIFIED	
MFG. APPR: VM 10/19/2017	DATE: 10/19/2017	INTERPRET DIM AND TOL PER ASME Y14.5-2009	
APPROVED BY: VM 11/02/2017	DATE: 11/02/2017	3. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE: NTS	WEIGHT: N/A	SHEET 1 OF 4	
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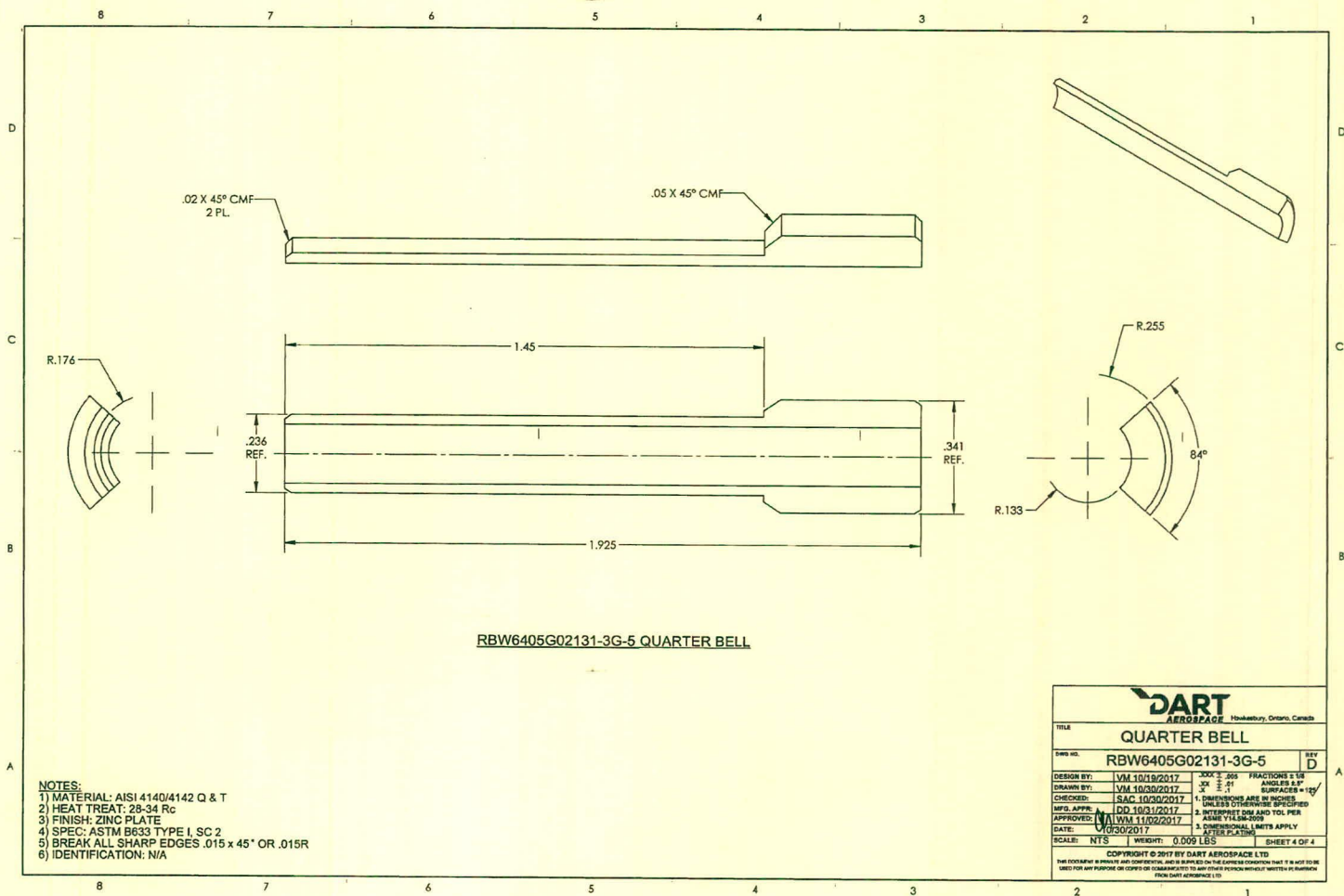


RBW6405G02131-3G-3 BELL

NOTES:

- 1) MATERIAL: 6061-T6
- 2) HEAT TREAT: N/A
- 3) FINISH: CLEAR ANODIZE
- 4) SPEC: MIL-A-8625, TYPE II, CLASS 1; WATER SEALANT
- 5) BREAK ALL SHARP EDGES .015 X 45° OR .015R
- 6) IDENTIFICATION: MACHINE ENGRAVE PER CAD FILE LATEST REV T/N & S/N, 0.010" DEPTH

DART AEROSPACE	
Hawthornbury, Ontario, Canada	
BELL	
DESIGN NO.	REV
RBW6405G02131-3G-3	D
DESIGN BY: VM 10/18/2017	CHKD: 3-265
DRAWN BY: VM 10/30/2017	3-2-21
CHECKED: SAC 10/30/2017	1. PARTS ARE ALL FINISHED
INFO. APPR: VM 10/31/2017	2. UNLESS OTHERWISE SPECIFIED
DATE: 10/30/2017	3. INTERPRET DIM AND TOL PER
SCALE: NTS	4. DIMENSIONAL LIMITS APPLY
WEIGHT: 0.057 LBS	5. AFTER PLATING
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- NOTES:
- 1) MATERIAL: AISI 4140/4142 Q & T
 - 2) HEAT TREAT: 28-34 Rc
 - 3) FINISH: ZINC PLATE
 - 4) SPEC: ASTM B633 TYPE 1, SC 2
 - 5) BREAK ALL SHARP EDGES .015 X 45° OR .015R
 - 6) IDENTIFICATION: N/A

DART AEROSPACE	
Horseshoe, Ontario, Canada	
QUARTER BELL	
DESIGN NO.	REV
RBW6405G02131-3G-5	D
DESIGN BY:	DATE
VM 10/18/2017	0001 3 266
DRAWN BY:	DATE
VM 10/30/2017	0001 3 266
CHECKED:	DATE
SAC 10/30/2017	0001 3 266
APPROVED:	DATE
VM 11/02/2017	0001 3 266
DATE:	DATE
10/30/2017	0001 3 266
SCALE:	WEIGHT:
NTS	0.009 LBS
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SHEET 4 OF 4	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041367**

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO041367

PO Date: 10/16/18

Due Date: 12/17/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Revised

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	185295	RBW6005G01631-3GP			Dial Indicator Swash Plate Scissors Support REV A	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$1,150.00/pcs	\$2,300.00
Line Item Note: SIOP													
2	185392	RBW1205G00231-3GP			Main Rotor Damper Oil Filling Adapter REV 2B	Firmed	-	12/17/18	3 pcs	0 pcs	3 pcs	\$1,000.00/pcs	\$3,000.00
Line Item Note: SIOP													
3	185298	RBW6405G00332-3GP			Tail Rotor Pitch Control Adjustment Tool REV 5	Firmed	-	12/17/18	1 pcs	0 pcs	1 pcs	\$1,500.00/pcs	\$1,500.00
Line Item Note: SIOP													
4	185299	RBW6005G01531-3GP			Dial Indicator Main Rotor Damper Support REV 2	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$900.00/pcs	\$1,800.00
Line Item Note: SIOP													
5	185300	RBW6405G00531-3GP			Tail Rotor Damper Length Adjustment Tool REV A	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$700.00/pcs	\$1,400.00
Line Item Note: SIOP													
6	185301	RBW6405G02131-3GP			Tail Rotor Blade Damper Attachment Bushing Removal REV D	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$500.00/pcs	\$1,000.00
Line Item Note: SIOP													
7	185302	RBW6205G05951-3GP			RBW6205G05951-3GP REV 2	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$450.00/pcs	\$900.00
Line Item Note: SIOP													



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Hawkesbury, ON
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Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041367**

Items													
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
8	185303	RBW3205G00151-3GP			Main Landing Gear R&R Wrench REV 2	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$400.00/pcs	\$800.00
Line Item Note: SIOP 2X DEC 18 2018 ORDER 7393 22 Jan 2019													
9	185349	RBW6205G26631-3GP			Wrench, MR Scissor Retaining Nut Removal/Install REV 2	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$280.00/pcs	\$560.00
Line Item Note: SIOP													
10	185352	RBW6205G26551-3GP			Main Rotor Scissor Locknut REV B	Firmed	-	12/17/18	2 Ea	0 Ea	2 Ea	\$175.00/Ea	\$350.00
Line Item Note: SIOP 2X DEC 17 2018													
11	185353	RBW109-3101-58-2P			Hammer, Aluminum, Blade Corrosion and Voids Detection REV 3	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$150.00/pcs	\$300.00
Line Item Note: SIOP 2X DEC 18 2018													
12	185354	RBW109-3101-58-1P			Hammer, Steel, Blade Corrosion and Voids Detection REV 3	Firmed	-	12/17/18	1 pcs	0 pcs	1 pcs	\$150.00/pcs	\$150.00
Line Item Note: SIOP 1X DEC 18 2018													
13	185406	RBW6205G03451-3GP			Bolt Guide Removal & Install REV 2B	Firmed	-	12/17/18	3 Ea	0 Ea	3 Ea	\$625.00/Ea	\$1,875.00
Line Item Note: SIOP ORDER 7393 22 Jan 2018													
14	185407	RBW6205G08451-3GP			Puller Bolt Removal REV 2B	Firmed	-	12/17/18	3 Ea	0 Ea	3 Ea	\$625.00/Ea	\$1,875.00
Line Item Note: SUB ASSEMBLY OF RBW6205G00331-3G 3X DEC 17 2018 ORDER 7393 22 Jan 2018													
15	185423	RBW6205G08031-3GP			Main Rotor Flanged Bushing Removal Tool REV 2	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$1,125.00/Ea	\$1,125.00
Line Item Note: SUB ASSEMBLY OF RBW6205G00331-3G 1X DEC 17 2018 ORDER 7393 22 Jan 2018													
16	185424	RBW6205G08131-3GP			Main Rotor Flanged Bushing Install Tool REV 2	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$1,125.00/Ea	\$1,125.00
Line Item Note: SUB ASSY FOR RBW6205G06231-3G 1X DEC 17 2018 ORDER 7393 22 Jan 2018													
17	185429	RBW6405G08832-3GP			Tail Rotor Bushing Install Tool As Per Dwg RBW6405G08832-3G Rev/ D	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$875.00/Ea	\$875.00
Line Item Note: SUB ASSY FOR RBW6405G08632-3G ORDER 7393 08 Jan 2019													



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041367**

Items													
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
18		RBW6405G08732-3GP			Tail Rotor Bushing Removal Tool RBW6405G08732-3G Rev. E	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$875.00/Ea	\$875.00
Line Item Note SUB ASSY FOR RBW6405G08632-3G													
19	185430	RBW6205G10451-3GP			Threaded Rod	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$208.33/Ea	\$208.33
Line Item Note SUB ASSY FOR RBW6205G08931-3G													
20	185431	RBW6205G10551-3GP			Hammer	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$208.33/Ea	\$208.33
Line Item Note SUB ASSY FOR RBW6205G08931-3G													
21	185432	RBW6205G10351-3GP			Guide REV 1	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$208.33/Ea	\$208.33
Line Item Note SUB ASSY FOR RBW6205G08931-3G													
22	185433	RBW6205G10251-3GP			Threaded Rod	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$208.33/Ea	\$208.33
Line Item Note SUB ASSY FOR RBW6205G08931-3G													
23	185434	RBW6205G10151-3GP			Pusher REV 1	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$208.33/Ea	\$208.33
Line Item Note SUB ASSY FOR RBW6205G08931-3G													
24	185435	RBW6205G10651-3GP			Stop	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$208.33/Ea	\$208.33
Line Item Note SUB ASSY FOR RBW6205G08931-3G													
25	185461	RBW6305G26631-3G-1P			Pin REV 2	Firmed	-	12/17/18	8 Ea	0 Ea	8 Ea	\$56.25/Ea	\$450.00
Line Item Note SUB ASSY FOR RBW6305G26631-3G													
26	185462	RBW6305G26631-3G-3P			Handle REV 2	Firmed	-	12/17/18	8 Ea	0 Ea	8 Ea	\$56.25/Ea	\$450.00
Line Item Note SUB ASSY FOR RBW6305G26631-3G													
Grand Total:												\$23,959.98	

Order Notes

Procurement Quality Clauses
 A005 RIGHT OF ENTRY
 A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
 A012 CHEMICAL AND PHYSICAL TEST REPORTS
 A016 PERSONNEL QUALIFICATION
 A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
 A026 CERTIFICATION OF MATERIAL CONFORMANCE
 A041 QUALITY MANAGEMENT SYSTEM
 A042 DART NOTIFICATION BY SUPPLIER
 A043 RETENTION OF QUALITY DOCUMENT
 A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
 A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Packing List

Bill Dart Aerospace Ltd.
To: 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 Canada

Ship Dart Aerospace Ltd.
To: 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 Canada

Shipment No: 24408
Shipment Date: 18-Dec-2018
Ship Via: Pick up at METEC

Customer Code: DART
Phone: (613) 632-9577

Terms: Net 60 Days

----- Quantity -----								
<u>Item</u>	<u>Open</u>	<u>Shipped</u>	<u>B/O</u>	<u>Canceled</u>	<u>Unit</u>	<u>Description</u>	<u>Revision</u>	<u>Job Number</u>
2	1	1 ✓	0	0	EA	DART-RBW6205G03832-3GP M/R Blade Blocking/Protecting Assy Order No: 3091 Order Date: 10/12/18 PO Number: PO041327 ✓	5 ✓	3091-02
4	2	2 ✓	0	0	EA	DART-RBW6005G01531-3GP Dial Indicator Main Rotor Damper Support Order No: 3096 Order Date: 10/17/18 PO Number: PO041367 ✓	2	3096-04
5	2	2	0	0	EA	DART-RBW6405G00531-3GP Tail Rotor Damper Length Adjustment Tool Order No: 3096 Order Date: 10/17/18 PO Number: PO041367 ✓	A	3096-05
6	2	2 ✓	0	0	EA	DART-RBW6405G02131-3GP Tail Rotor Blade Damper Attachment Bushing Removal Order No: 3096 Order Date: 10/17/18 PO Number: PO041367 ✓	D	3096-06
7	2	2 ✓	0	0	EA	DART-RBW6205G05951-3GP Main Rotor Damper Rod End Wrench Order No: 3096 Order Date: 10/17/18 PO Number: PO041367 ✓	2	3096-07
8	2	2 ✓	0	0	EA	DART-RBW3205G00151-3GP Main Landing Gear Wrench Order No: 3096 Order Date: 10/17/18 PO Number: PO041367 ✓	2	3096-08

DAS
38
9-89



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Dwg Rev.#	P.O. Number
2 ✓	DART-RBW6005G01531-3GP ✓	Dial Indicator Main Rotor Damper Support	2	41367 ✓
2 ✓	DART-RBW6405G02131-3GP ✓	Tail Rotor Blade Damper Attachment Bushing Removal	2	41367 ✓
2 ✓	DART-RBW6205G05951-3GP ✓	Main Rotor Damper Rod End Wrench	2	41367 ✓
1 ² ✓	DART-RBW6205G26631-3GP ✓	Wrench, Special Nut Removal/Installation	D	41367 ✓
1	DART-RBW6405G08832-3GP	Tail Rotor Bushing Install Tool	E	41367
1	DART-RBW6405G08732-3GP	Tail Rotor Bushing Removal Tool	5	41367
1 ✓	DART-RBW6205G03832-3GP ✓	M/R Blade Blocking/Protecting Assy	5	41367 ✓
2	DART-RBW6405G00531-3GP	Tail Rotor Damper Length Adjustment Tool	2	41367
2 ✓	DART-RBW3205G00151-3GP ✓	Main Landing Gear Wrench	2	41367 ✓

MATERIAL: supplied by METEC

We hereby certify that the above parts were made in conformance with applicable drawings.

